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(71) Applicants

Nauchno-

Proizvodstvennoe

Obedinenie Po

Tekhnologii

Mashinostroeniya

(Tsnitmash), Sharikopod-

shipnikovskaya, Ulitsa 4,

Moscow, Soviet Union

(72) Inventors

Yuly Moiseevich

Yunovich,

Viktor Naumovich

Pertsovsky,

Igor Petrovich Renzhin,

Sergei Semenovich

Zhukovsky,

Vyacheslav Sergeevich

Kolesnikov,

Olga Evgenevna Nevskaya

(74) Agents

Marks & Clerk, 57—60

Lincoln's Inn Fields,

London WC2A

(54) Self-hardening compound for making casting moulds and cores

(57) A self-hardening compound for making casting moulds and cores containing a refractory filler, orthophosphoric acid, a magnesia-spinellid-type compound roasted at a temperature of 1600 to 1900°C during 40 to 1600 hours, and water at

the following ratio of the said components in parts by weight:

orthophosphoric acid	2—10
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the said magnesia-spinellid-type compound	2—20
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water	0.5—6.0
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refractory filler	balance
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GB 2 070 627 A